



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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D350-822-011
Job Sheet 201440



Part No: D350-822-011

Job Qty: 1 pcs ✓

Part Name: PA100 PUREair System for AS350/EC130



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/3/19

Job Tracking No:

Due Date: 11/11/19

Created By: Marie Lajeunesse

Type: Stock

Description: SIOP

Note: IIN-D350-822 REV.I IPP REV:A 14.02.20 NEW ISSUE DD VERF:JLM IPP REV:B 14.06.18 AS PER IIN REV.C DD VERF:JLM IPP REV:C 15.06.03 AS PER IIN REV.D DD VERF:JLM IPP REV:C 18.07.11 AS PER IIN REV.H DD VERF:JFS IPP REV:D 19.04.16 AS PER CHG006 DD VERF:JFS/IPP Rev. E 19.08.09 as per CHG007 DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier	Sign-off
					Setup Hrs	Run Hrs		
90	Packaging 1 - Pick Kit	1 pcs ✓		11/11/19	0.00	0.00	Packaging 1 - 1	
							Packaging 1 - 2	
							Packaging 1 - 3	
							Packaging 1 - 4	
							Packaging 1 - 5	
							Packaging 1 - 6	
							Packaging 1 - 7	
							Packaging 1 - 8	
							Packaging 1 - 9	
							Packaging 1 - 10	
							Packaging 1 - 11	
							Packaging 1 - 12	
							Packaging 1 - 13	
							Packaging 1 - 14	
							Packaging 1 - 15	
							Packaging 1 - 16	
							Packaging 1 - 17	
							Packaging 1 - 18	
							Packaging 1 - 19	
							Packaging 1 - 20	
							Packaging 1 - 21	
							Packaging 1 - 22	
							Packaging 1 - 23	
							Packaging 1 - 24	
							Packaging 1 - 25	
							Packaging 1 - 26	
							Packaging 1 - 27	
							Packaging 1 - 28	
							Packaging 1 - 29	



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Container No: S226050



Part: D350-822-011

Job No: 201440

Serial No/Batch: S226050

Revision: 1

Inspector:

Exp Date:

Instructions: TC STC SH14-14 - Issue 2, FAA STC SR0353

Plex 10/3/19 1:16 PM Dart.lajeunesse.marie

110 Packaging 1-1 - Pick Kit - B4B 1 pcs	11/11/19	0.00 0.00	Packaging 1 - 30	
			Packaging 1 - 31	
			Packaging 1 - 32	
			Packaging 1 - 33	
			Packaging 1 - 34	
			Packaging 1 - 35	
			Packaging 1 - 36	
			Packaging 1 - 1 - B4B	
			Packaging 1 - 2 - B4B	
			Packaging 1 - 3 - B4B	
			Packaging 1 - 4 - B4B	
			Packaging 1 - 5 - B4B	
			Packaging 1 - 6 - B4B	
			Packaging 1 - 7 - B4B	
			Packaging 1 - 8 - B4B	
			Packaging 1 - 9 - B4B	
			Packaging 1 - 10 - B4B	
			Packaging 1 - 11 - B4B	
			Packaging 1 - 12 - B4B	
			Packaging 1 - 13 - B4B	
			Packaging 1 - 14 - B4B	
			Packaging 1 - 15 - B4B	
			Packaging 1 - 16 - B4B	
			Packaging 1 - 17 - B4B	
			Packaging 1 - 18 - B4B	
			Packaging 1 - 19 - B4B	
			Packaging 1 - 20 - B4B	
			Packaging 1 - 21 - B4B	
			Packaging 1 - 22 - B4B	
			Packaging 1 - 23 - B4B	
			Packaging 1 - 24 - B4B	
			Packaging 1 - 25 - B4B	
			Packaging 1 - 26 - B4B	
			Packaging 1 - 27 - B4B	
			Packaging 1 - 28 - B4B	
			Packaging 1 - 29 - B4B	
			Packaging 1 - 30 - B4B	
			Packaging 1 - 31 - B4B	
			Packaging 1 - 32 - B4B	
			Packaging 1 - 33 - B4B	
			Packaging 1 - 34 - B4B	
			Packaging 1 - 35 - B4B	
			Packaging 1 - 36 - B4B	
120 QC 4	11/11/19	0.00 0.00	QC 4 - 28	
			QC 4 - 58	
			QC 4 - 69	
			QC 4 - 9	
			QC 4 - 46	
			QC 4 - 68	
			QC 4 - 72	
			QC 4 - 74	
			QC 4 - 75	
			QC 4 - 78	
125 Outsource - 10 - Consignment 1 pcs	11/11/19	0.00 0.00		
130 Packaging 3-1 - Stock - B4B 1 pcs	11/11/19	0.00 0.00	Packaging 3 - 1 - B4B	
			Packaging 3 - 2 - B4B	
			Packaging 3 - 3 - B4B	
			Packaging 3 - 4 - B4B	
			Packaging 3 - 5 - B4B	

OCT 25 2019

OCT 25 2019 OCT 25 2019

DAS
78
9-89

				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	DAS
135 DC - 1 - B4B	1 pcs	11/11/19	0.00 0.00	DC - 1 - B4B	21
				DC - 2 - B4B	9-89
140 QC 21 - FG	1 pcs	11/11/19	0.00 0.00	QC 21 - FG - 21	OCT 2 5 2019
				QC 21 - FG - 70	DAS
				QC 21 - FG - 53	21
					9-89

Part Op 90 - Pick kit

Descriptions: 110 - Pick Kit

120 - QC4- 100% Inspect kits for completeness

125 - Issue PO to GL account 67005-186-0000 to LEAVE W/O OPEN UNTIL SOLD PO 44988 (Send copy of PO to Pall - James) Issue W/O LINE item for Pall for amount sold on sales order S/O 16556 according to sales price see Caroline for amount. (if sale price is \$23,000 - amount is \$13,400) PO can be received immediately and given to finance in order to close work order.

130 - Identify and pack for shipping as per PPP D350-822-011

135 - Photocopy bluefile & type labels per PPP D350-822-011 CHG007

140 - QC21- Final Inspection - Work Order Release

(012393)

Part / Item	Component Name	Quantity	Operation	Container
650.0401	Pureair Fairing Assembly	1 pcs (1 ea)	90-Packaging 1 - Pick Kit	B4B S222510
9752100180	Gasket	1 Ea (1 ea)	90-Packaging 1 - Pick Kit	S195278
9945000120	Gasket (for B3e models)	1 pcs (1 ea)	90-Packaging 1 - Pick Kit	S195279
AN821-12J	Elbow (or AN821-12K or 12S)	2 Ea (2 ea)	90-Packaging 1 - Pick Kit	S219466
AN829-12J	Cap	1 Ea (1 ea)	90-Packaging 1 - Pick Kit	S218599
D4925-041	Mounting Plate Assembly	1 pcs (1 ea)	90-Packaging 1 - Pick Kit	S213693 S218211
D4931-1	Engine Fitting (for acft models B2 & previous)	1 pcs (1 ea)	90-Packaging 1 - Pick Kit	S192072
D4931-3	Engine Fitting (For B3 Models)	1 pcs (1 ea)	90-Packaging 1 - Pick Kit	S192905
D4931-5	Engine Fitting (for B3e models)	1 pcs (1 ea)	90-Packaging 1 - Pick Kit	S192914
D4935-1	Mounting Bracket	6 pcs (6 ea)	90-Packaging 1 - Pick Kit	S213365
D4943-1	Flex Hose	1 pcs (1 ea)	90-Packaging 1 - Pick Kit	S199091
D4961-041	Tube Assembly	1 pcs (1 ea)	90-Packaging 1 - Pick Kit	S222069
D4961-043	Tube Assembly	1 pcs (1 ea)	90-Packaging 1 - Pick Kit	S199119
D5079-1	Placard, Eaps	2 pcs (2 ea)	90-Packaging 1 - Pick Kit	S127945
D5090-041	Duct Assembly	1 pcs (1 ea)	90-Packaging 1 - Pick Kit	S219555
D5105-1	Handle	2 pcs (2 ea)	90-Packaging 1 - Pick Kit	S209346
D5110-1	Swivel Nut Fitting	1 pcs (1 ea)	90-Packaging 1 - Pick Kit	S200764
D5179-1	Doubler	2 pcs (2 ea)	90-Packaging 1 - Pick Kit	S212892
D5179-3	Doubler	2 pcs (2 ea)	90-Packaging 1 - Pick Kit	S212879
D5194-1	Doubler	2 pcs (2 ea)	90-Packaging 1 - Pick Kit	S220028
D5208-041	Blanking Plate Assembly	3 pcs (3 ea)	90-Packaging 1 - Pick Kit	S218626
LN9038-05012	Bolt	36 pcs (36 ea)	90-Packaging 1 - Pick Kit	S181020
LN9038-05040	Bolt	1 pcs (1 ea)	90-Packaging 1 - Pick Kit	S119862
LN9348-05	Nut	32 pcs (32 ea)	90-Packaging 1 - Pick Kit	S221514
MS20470AD3-4	Rivet, Universal Head	18 Ea (18 ea)	90-Packaging 1 - Pick Kit	F136665
MS21919WCH12	Clamp	1 Ea (1 ea)	90-Packaging 1 - Pick Kit	S131208
MS9592-138	Bracket	1 pcs (1 ea)	90-Packaging 1 - Pick Kit	S197846
NAS1149D0332J	Washer	70 Ea (70 ea)	90-Packaging 1 - Pick Kit	S178378
NAS43DD3-64	Spacer	1 Ea (1 ea)	90-Packaging 1 - Pick Kit	S174223
22208CM050016E	Screw	2 pcs (2 ea)	90-Packaging 1 - Pick Kit	S197860
23350CA050	Washer	2 Ea (2 ea)	90-Packaging 1 - Pick Kit	S167662
736	Heat Resistant Sealant 3 OZ tube	1 Ea (1 ea)	90-Packaging 1 - Pick Kit	S200141
9945000160	Gasket	1 Ea (1 ea)	90-Packaging 1 - Pick Kit	S198095
D5526-1	Upper Hose Protector	1 pcs (1 ea)	90-Packaging 1 - Pick Kit	S175165
D5526-3	Lower Hose Protector	1 pcs (1 ea)	90-Packaging 1 - Pick Kit	S175576
D5721-1	Heat Barrier	1 pcs (1 ea)	90-Packaging 1 - Pick Kit	S181970
LN9038-05016	Bolt	2 pcs (2 ea)	90-Packaging 1 - Pick Kit	S117992
BS4320-A5	Washer	56 Ea (56 ea)	110-Packaging 1-1 - Pick Kit - B4B	S226530
LN29985-A05	Anchor Nut	15 pcs (15 ea)	110-Packaging 1-1 - Pick Kit - B4B	S226534
LN9038-05018	Bolt	56 pcs (56 ea)	110-Packaging 1-1 - Pick Kit - B4B	S226534
MS20426AD3-3	Rivet	40 Ea (40 ea)	110-Packaging 1-1 - Pick Kit - B4B	S226534
QB21304	Pureair Panel Assembly	1 pcs (1 ea)	110-Packaging 1-1 - Pick Kit - B4B	S226534
QB21310	Transition Duct Assembly	1 pcs (1 ea)	110-Packaging 1-1 - Pick Kit - B4B	S226534
QB23753	Fod Screen Assembly	1 Ea (1 ea)	110-Packaging 1-1 - Pick Kit - B4B	S226534
QR10616	Vortex Tube Repair	1 pcs (1 ea)	110-Packaging 1-1 - Pick Kit - B4B	S226534

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
90-Packaging 1 - Pick Kit	22208CM050016E	2	34	0
	23350CA050	2	36	0
	650.0401	1	9	0
	736	1	13	0
	9752100180	1	33	0
	9945000120	1	30	0
	9945000160	1	30	0
	AN821-12J	2	5	0
	AN929-12J	1	32	0
	D4925-041	1	13	0
	D4931-1	1	23	0
	D4931-3	1	24	0
	D4931-5	1	19	0
	D4935-1	6	86	0
	D4943-1	1	34	0
	D4961-041	1	6	0
	D4961-043	1	14	0
	D5079-1	2	24	0
	D5090-041	1	1	0
	D5105-1	2	21	0
	D5110-1	1	22	0
	D5179-1	2	46	0
	D5179-3	2	80	0
	D5194-1	2	12	0
	D5208-041	3	16	0
	D5526-1	1	25	0
	D5526-3	1	23	0
	D5721-1	1	37	0
	LN9038-05012	36	371	0
	LN9038-05016	2	20	0
	LN9038-05040	1	63	0
	LN9348-05	32	366	0
	MS20470AD3-4	18	5,297	0
	MS21919WCH12	1	19	0
	MS9592-138	1	44	0
	NAS1149D0332J	70	1,582	0
	NAS43DD3-64	1	34	0
110-Packaging 1-1 - Pick Kit - B4B	BS4320-A5	56	286	0
	LN29985-A05	15	360	0
	LN9038-05018	56	1,540	0
	MS20426AD3-3	40	6,022	0
	QB21304	1	5	0
	QB21310	1	5	0
	QB23753	1	6	0
	QR10616	1	5	0
Part Specifications				
Specifications could not be found.				

Plex 10/3/19 1:16 PM Dart.lajeunesse.marie



Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____		DISPOSITION		DEPARTMENT/PROCESS											
Part No. _____		Rework ☐ Scrap ☐ Use-as-is ☐		Skid-tube ☐ Machining ☐ Large Fab ☐		Cross tube ☐ Small Fab ☐ Finishing ☐		Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐		Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐					
Date :	Sequence #:	QTY Affected :		MRB (QSI042)											
Description Work Order Deviation				Disposition											
Completed By				Lead hand / Supervisor											
QC / QA Coordinator															
Root Cause				FAULT CATEGORY											
				Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Other/Details: _____				Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐				Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐			
Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐															

5.0 PARTS LIST

QTY -011	QTY -013	PART NUMBER	DESCRIPTION
X		D350-822-011	PA100 PUREAIR SYSTEM
	X	D350-822-013	PA100 PUREAIR PROVISIONS
1		QB05008	PUREAIR SYSTEM
1**		QR10616	TUBE REPAIR KIT
1**		QB21304	PUREAIR PANEL ASSY
1**		QB21310	TRANSITION DUCT ASSY
1**		QB23753	FOD SCREEN ASSY (REPLACES QB21308)
15**		LN29985-A05	ANCHOR NUT
56**		LN9038-05018	BOLT
56**		BS4320-A5	WASHER
40**		MS20426AD3-3	RIVET
1	1	650.0401	PUREAIR FAIRING ASSY
1	1	D4925-041	MOUNTING PLATE ASSY
1*	1*	D4931-1	ENGINE FITTING
1*	1*	D4931-3	ENGINE FITTING
1*	1*	D4931-5	ENGINE FITTING
6	6	D4935-1	MOUNTING BRACKET
1	1	D4943-1	FLEX HOSE
1	1	D4961-041	TUBE ASSEMBLY
1	1	D4961-043	TUBE ASSEMBLY
2	2	D5079-1	PLACARD
1	1	D5090-041	DUCT ASSEMBLY
2	2	D5105-1	HANDLE
1	1	D5110-1	SWIVEL NUT FITTING
2	2	D5179-1	DOUBLER
2	2	D5179-3	DOUBLER
2	2	D5194-1	DOUBLER
3	3	D5208-041	BLANKING PLATE ASSY
1	1	D5526-1	HOSE PROTECTOR
1	1	D5526-3	HOSE PROTECTOR
1	1	D5721-1	HEAT BARRIER
2	2	23350CA050	LOCKING TAB
1*	1*	9752100180	GASKET
1*	1*	9945000120	GASKET
1*	1*	706A33-201-001	GASKET (OR 9945000160)
2	2	22208CM050016E	SCREW
1	1	736	HEAT RESISTANT SEALANT
2	2	AS1034J1212	ELBOW (OR AN821-12K OR AN821-12S OR AN821-12J)
1	1	AN929-12J	CAP
70	70	BS4320-A5	WASHER (OR NAS1149D0332J)
36	36	LN9038-05012	BOLT
2	2	LN9038-05016	BOLT
1	1	LN9038-05040	BOLT
32	32	LN9348-05	NUT
18	18	MS20470AD3-4	RIVET
1	1	MS21919WCH12	CLAMP (OR MS21919WHG12)
1	1	MS9592-138	BRACKET
1	1	NAS43DD3-64	SPACER

* USE APPROPRIATE FITTING/GASKET BASED ON ENGINE INSTALLATION
 ** PART OF QB05008 ABOVE

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Revision: I

Date: 19.03.15

Change Record

Part Number: D350-822-011

PAGE 1 OF 1

Description: PA100 PUREAIR SYSTEM

[illegible]

PALL Aerospace

PRODUCTION ACCEPTANCE TEST CERTIFICATE

This is an Electronically controlled document which is maintained with Full Password Access for all users. The "Insp Stamp" column relates to an individual whose password is electronically controlled, a "wet stamp" is therefore no longer required.

Test Unit Desc	Centrisep EAPS	Issue	4	Report No:	FC/063
Drawing No	QB05008	Amdnt		Serial No.	RF7-711Z
Part No	QB05008			Batch No.	RD19014885
ECR / Concession No					
Cust Spec	RSB05008	Test Sched	ATPB05008	Issue	5
Test Fluid	Air	Test Set-up		Issue	
Rig Or Test No					
Comment		Assembler	MARK WEAVER	Tester	IAN LUGGINS
Insp/Approved By		Clock No.	08003105	Date	15/10/2019

	PROCEDURE	REQUIREMENT	RESULT	Pass/Fail
3.1	Check that the label requirements and part marking are in accordance with Sheet 2	Confirm	CONFIRMED	PASS
3.2	Ensure the QB05008 assembly conforms to the QB05008 Sheet 2 dimensions.	Confirm	CONFIRMED	PASS
3.3	Check the weight of the unit does not exceed 10kg.	Confirm	8.4 Kg	PASS
3.4	Check that proof pressure and crack detect tests have been performed on manifold.	Confirm	CONFIRMED	PASS
3.5	Check FOD screen mesh is intact with no broken mesh strands or irregular deformation.	Confirm	CONFIRMED	PASS
3.6	Check manifold port thread engagement. Ensure protective cap is fitted.	Confirm	CONFIRMED	PASS
3.7	Check electrical bonding resistance is equal to or less than 100 milliohms.	Confirm	1 n Ohm	PASS
4.1	Check overall unit cleanliness.	Confirm	CONFIRMED	PASS
4.1 a	Check there are no material imperfections or foreign matter embedded.	Confirm	CONFIRMED	PASS
4.1 b	Check surface for unclean, rough, misaligned or containing cracks, nicks or other flaws.	Confirm	CONFIRMED	PASS
4.1 c	Check for any components that are missing, malformed, fractured or otherwise damaged.	Confirm	CONFIRMED	PASS
4.1 d	Check for any components that are loose or otherwise not securely retained.	Confirm	CONFIRMED	PASS
4.1 e	Check for incorrect assembling or improper positioning of components.	Confirm	CONFIRMED	PASS